

SPECIFICATION AMENDMENTS

Page 7, replace the paragraph beginning at line 14 with the following new paragraph:

--As seen ~~if~~ in Fig. 5, each casting mould 16 preferably includes a two piece mould body 17 machined from aluminum which includes an annular channel 26 within the mould body. A refractory entry channel 19 can also be included with the mould 16, and that mates at its inlet end with a downstream end of the drop-down trough section 24. The mould is further lined with a graphite member 21. The channel 26 is connected to a second coolant supply line 28 and includes at least one annular slot or a plurality of holes 32 running from the channel 26 to a surface of the casting mould 16 adjacent the emerging ingot 18. Coolant from the second coolant supply line 28 flows out through the slot or holes 32 to impinge against the skin formed on the emerging ingot 18, thereby cooling and solidifying the ingot 18. A gas supply line 30 is also connected to the channel 26 to supply gas for clearing the slot or holes 32 of coolant and preventing the entry of molten metal 12. Another embodiment of mould suitable for use is described in co-pending application Serial No. 10/735,076 filed December 11, 2003 (~~Attorney's Docket No. 71743 CCD~~), entitled "Horizontal Continuous Casting of Metals", assigned to the same assignee as the present invention, the disclosure of which is incorporated herein by reference.--

Page 8, replace the paragraph beginning at line 5 with the following new paragraph:

--The flowchart of Fig. 6 illustrates some possible reasons for shutting down a particular strand of a multi-strand casting machine 10, and the subsequent steps that can be taken to isolate and shut down the strand. The breakout detector may be any sensor capable of identifying a liquid metal leak from the mould, but is

preferably one as described in US Patent 6,446,704 (Collins) incorporated herein by reference. Other faults that may cause the sequence of events in the flowchart to occur include failure of a cutoff saw used to cut the continuously emerging ingot into sections or loss of synchronization between the ingot withdrawal mechanism and the ingot movement. The apparatus that may give rise to these types of shutdown events is described in co-pending application Serial No. 10/735,077 filed December 11, 2003 (~~Attorney's Docket No. 71744-CCD~~), entitled "Apparatus and Method for Horizontal Casting and Cutting of Metal Billets", assigned to the same assignee as the present invention, the disclosure of which is incorporated herein by reference.--